

Shp Monday 26/03

Work Order ID 80523

80523

Page 1

Wednesday, February 22, 2012 1:37:51 PM

Item ID: D139-799-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cargo Door Hinge
 Start Date: 2/22/2012 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 2/22/2012 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: [Signature] Date: 2/22/22 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D139-799	F

100 [Signature] 0.00

100

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D139-799-013
 CHG004

0.00

5/26/26

MCU 12/03/23

[Signature]

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

SP 12-03-23

[Signature]

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

5/26/26

[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80523***80523***

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Wednesday, February 22, 2012 1:37:51 PM

Item ID: D139-799-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cargo Door Hinge

Start Date: 2/22/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 2/22/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D139-799-013								
	Location: <u>31</u>								
	PPP rev: <u> </u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

6/13/26 50 9MLJ 12/03/2612-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, February 22, 2012 1:37:55 PM

Page 1

Work Order ID: 80523

80523

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 2/22/2012

Required Date: 2/22/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:JLM IPP REV:B
AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD
IPP REV:C AS PER DSI9567 revA 11.10.17 DD VERF:EC IPP
REV:D 12.01.19 per iin rev.f ecn 12-507 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2585		Manufactured	No			110	Each	78.0000	1	5			
<p>*D2585* Mounting Channel</p>													

Location	Loc Qty	Loc Code
ST011	78	
73297	2	
77696	17	
78805	59	

D2586		Manufactured	No			110	Each	69.0000	1	5			
<p>*D2586* Door Latch</p>													

Location	Loc Qty	Loc Code
ST203A	69	
77697	69	

D2621		Manufactured	No			110	Each	43.0000	1	5			
<p>*D2621* Latch Plate, 350 Spacepod</p>													

Location	Loc Qty	Loc Code
ST013	43	
73304	4	
78991	39	

SP 12-03-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 2/22/2012

Required Date: 2/22/2012

Start Qty: 5.00

Required Qty: 5.00

D3552-23

Manufactured No

110

Each

11.0000

1

5

D3552-23

Door Prop

**

B 80347

Location

Loc Qty

Loc Code

ST272A

11

74847

6

79272

5

D3622-1

Manufactured No

110

Each

30.0000

1

5

D3622-1

Ball Stud

**

SP

Location

Loc Qty

Loc Code

ST058

30

78837

30

D3622-3

Manufactured No

110

Each

15.0000

1

5

D3622-3

Ball Stud

**

SP

Location

Loc Qty

Loc Code

ST058

15

53951

4

77023

11

D4072-1

Manufactured No

110

Each

20.0000

2

10

D4072-1

Airframe Hinge

**

SP 12-03-26

Location

Loc Qty

Loc Code

ST120

20

78530

20

10x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 2/22/2012

Required Date: 2/22/2012

Start Qty: 5.00

Required Qty: 5.00

D4072-3 Manufactured No

110 Each 30.0000 2 10

D4072-3

Airframe Hinge Backing Plate

**

Location

Loc Qty

Loc Code

ST120

30

76989

7

78529

23

D4072-5 Manufactured No

110 Each 23.0000 4 20

D4072-5

Bushing

**

Location

Loc Qty

Loc Code

ST120

23

78526

23

D4073-1 Manufactured No

110 Each 10.0000 2 10

D4073-1

Door Hinge

**

Location

Loc Qty

Loc Code

ST120

10

78528

10

D4073-3 Manufactured No

110 Each 19.0000 2 10

D4073-3

Door Hinge Backing Plate

**

Location

Loc Qty

Loc Code

ST120

19

78527

19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 2/22/2012

Required Date: 2/22/2012

Start Qty: 5.00

Required Qty: 5.00

D4074-1 Manufactured No

110 Each 18.0000

** 5

D4074-1

Bracket

Location

Loc Qty

Loc Code

ST120

18

76338

18

110 Each

6.0000

** 5

D4074-3

Manufactured No

D4074-3

Channel

Location

Loc Qty

Loc Code

ST120

6

72110

6

110 Each

98.0000

** 5

D4074-5

Manufactured No

D4074-5

Backing Plate

Location

Loc Qty

Loc Code

ST120

98

74495

96

76339

2

110 Each

22.0000

** 5

D4074-7

Manufactured No

D4074-7

Striker Plate

Location

Loc Qty

Loc Code

ST120

22

75624

6

76887

16

** 5

SP 12-03-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 2/22/2012

Required Date: 2/22/2012

Start Qty: 5.00

Required Qty: 5.00

D4519-1

Manufactured No

110

Each

22.0000

**

5

D4519-1

Relay Bracket

Location

Loc Qty

Loc Code

ST139E

22

79090

22

110

Each

4,225.000

**

100

MS21042L3

Purchased

No

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

4225

117441

16

117885

32

118451

5

118927

3

119017

3862

119075

307

110

Each

1,758.000

**

5

MS21042L5

Purchased

No

MS21042L5

Nut

Location

Loc Qty

Loc Code

ST300

1758

116105

5

116548

43

117611

42

118179

168

119109

1500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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80523

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 2/22/2012

Required Date: 2/22/2012

Start Qty: 5.00

Required Qty: 5.00

MS27039-1-10

Purchased

No

110

Each

260.0000

8

40

MS27039-1-10

Screw

**

Location

Loc Qty

Loc Code

GA

100

120449

100

ST291

160

120120

160

MS27039-1-14

Purchased

No

110

Each

204.0000

2

10

MS27039-1-14

Screw

**

Location

Loc Qty

Loc Code

GA

187

120177

87

120449

100

ST291

17

112312

17

MS27039-1-16

Purchased

No

110

Each

164.0000

8

40

MS27039-1-16

Screw

**

Location

Loc Qty

Loc Code

ST291

164

119902

64

120229

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 80523

80523

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 2/22/2012

Required Date: 2/22/2012

Start Qty: 5.00

Required Qty: 5.00

MS27039-1-17

Purchased

No

110

Each

137.0000

5

MS27039-1-17

Screw

**

Location

Loc Qty

Loc Code

GA

100

120142

100

ST291

37

117591

37

NAS1149D0363J

Purchased

No

110

Each

2,824.000

90

NAS1149D0363.1

Washer

**

Location

Loc Qty

Loc Code

ST298

2824

117601

61

118077

1

118612

18

119537

679

120142

386

120308

679

120644

1000

NAS1149D0663J

Purchased

No

110

Each

1,164.000

5

NAS1149D0663.1

Washer

**

Location

Loc Qty

Loc Code

ST298

1164

119075

664

120644

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 80523

80523

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 2/22/2012

Required Date: 2/22/2012

Start Qty: 5.00

Required Qty: 5.00

NAS1515H5L

Purchased

No

110

Each

114.0000

20

*NAS1515H5L *

WASHER

**

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

74

119902

74

Purchased

No

110

Each

61.0000

IN4007

IN4007

Diodes

**

Location

Loc Qty

Loc Code

ST390

25

120363

25

ST395

36

114970

11

117871

25

Purchased

No

110

Each

30.0000

M12883/41-19

M12883/41-19

Relay Base

**

Location

Loc Qty

Loc Code

ST395

30

120251

10

120414

20

Purchased

No

110

Each

242.0000

M39029/92-534

M39029/92-534

Socket Contact

**

Location

Loc Qty

Loc Code

ST511

242

120344

42

120363

200

Wednesday, February 22, 2012 1:37:56 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 80523

80523

Parent Item: D139-799-013

D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 2/22/2012

Required Date: 2/22/2012

Start Qty: 5.00

Required Qty: 5.00

-M83536/9-024M

Purchased

No

110

Each

30.0000

1

5

**

SP. 12-03-23



S *M83536/9-024M*

Relay

Location

Loc Qty

Loc Code

ST395

30

120251

10

120414

20

1x
4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D139-799

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Qty -013	Part Number	Description
X	D139-799-013	CARGO DOOR HINGE KIT
1	D2585	MOUNTING CHANNEL
1	D2586	DOOR LATCH
1	D2621	LATCH PLATE
1	D3552-23	DOOR PROP
1	D3622-1	BALL STUD
1	D3622-3	BALL STUD
2	D4072-1	AIRFRAME HINGE
2	D4072-3	AIRFRAME HINGE BACKING PLATE
4	D4072-5	BUSHING
2	D4073-1	DOOR HINGE
2	D4073-3	DOOR HINGE BACKING PLATE
1	D4074-1	BRACKET
1	D4074-3	CHANNEL
1	D4074-5	BACKING PLATE
1	D4074-7	STRIKER PLATE
1	D4519-1	RELAY BRACKET
1	IN4007	DIODE
1	M12883-41-19	RELAY BASE
4	M39029/92-534	SOCKET CONTACT
1	M83536/9-024M	RELAY
20	MS21042L3	NUT (or MS21042-3)
1	MS21042L5	NUT (or MS21042-5)
8	MS27039-1-10	SCREW
2	MS27039-1-14	SCREW
8	MS27039-1-16	SCREW
1	MS27039-1-17	SCREW
18	NAS1149D0363J	WASHER (or AN960JD10)
1	NAS1149D0663J	WASHER (or AN960JD616)
4	NAS1515H-5L	WASHER

Qty -023	Part Number	Description
X	D139-799-023	ANTI-ROTATION BLOCK KIT
5	D4310-1	BLOCK, ANTI-ROTATION
10	MS24665-115	PIN, COTTER

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Revision: F
Date: 11.10.20